		· · · · · · · · · · · · · · · · · · ·							- P	>		
Work Order ID May-06-14 8:09:15 AM	119001			*110	3001 <b>*</b>					• .		Page 1
Item ID: D3404-1 Revision ID:			A	ccept	*N900	040	100	)*	Setup S	tart	*N	S1*
Item Name: GHW/ Lu	g					•			S	Stop	*N!	S2*
Start Date: 5/05/14 Required Date: 5/05/14	Start Qty: 40. Req'd Qty: 40.		*40* *40*		Cust Item l Customer:	ID:						-
•	Plan: MLJ	Date: 14	<u>-05-07</u>	Tooling:	D	ate:	_	ì		start Stop	*NI	R1*
QC:		Date:		<b>SPC (Y/N):</b>	<b>D</b>	ate:				rop	*NI	R2*
Sequence ID/ Work Center ID	Operation Description	•		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp
Draw Nbr	Revision Nbr								, <u></u> ,	-		
D3404	Rev C					· ·						
100 <b>*100*</b> Bandsaw	BAND SAW Memo	•		0.00				40				14/06/6
Jeaspa Bandsaw		nk: 2.700" long										
											•	M/06/0
110				0.00							•	MM/19
*1 <sub>1</sub> 1	HAAS CNC VERT	ICAL MACHINING	G #1					40				16"
HAAS 1	Memo	•		0.00				<del></del>				Blech
HAAS CNC vertical machine #2	1 1-Mach	nine as per Folio FA	555 and Dwg	D3404Dwg Rev: <u>A</u>	}_Folio Rev:							14/00/00

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

120

Quality Control

DQA: Date:					. ΔΑΡΤ								
					WORK ORDER NON	I-CO	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only		
Work Order	<b>.</b> .				DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS		
Work Oraci	· — —				Rework	٦		Skid-tube Crosstube	Г		Water Jet	$\neg$	Engineering
Part No	<b>o</b> .				Scrap	1	,	Machining Small Fab	-	Pro	d. Eng. Coor.	ᅱ	Quality
				<del></del>	Use-as-is	1		noforming Finishing	$\vdash$	t	re/Packaging		Other
NCR No	o.				Suspected Unapproved	1		Large Fab Composite	-	<u> </u>	Supplier	╗	
											· · · · · · · · · · · · · · · · · · ·		
Root				Desc	ription of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	<u> </u>	QC Inspector
Design													
Doc/Data								·				1	
Equip/Tooling	_												•
Handling/Pre													
Material		1			•							ı	
Operator													
Offset/Setup	_							·				1	
Process	4												•
Supplier											<u>.</u>		
Training	-					1							
Transport	_												
Unapproved		1	<u> </u>	L		FΔ	ΙΙΙΤ CΔΊ	TEGORY		l	<u> </u>		
Landing	g Gear				General		OLI CA	120011					
Γ	Bending				Bend		] Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		ot Concei	ntric		BOM/Route	-	Grain			Over/Under	ŀ	_	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	are		Part Incorre	1		Temperature/Cure
		nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/M	issing		Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
\	Inspection	n Strip in	Tube		Drawing		Misread	d					
	Marks/C	hatter			Drill Holes		Off-set						
	Turning	Sequence			Finish		Out of	Calibration					
	Wave/Tv	vist in Tul	эe		Fit/Function		Out of	Sequence					

Work Order ID 119001 \*119001\* Page 2 May-06-14 8:09:15 AM Accept Item ID: D3404-1 \*N900040100\* Start Setup **Revision ID:** GHW/ Lug **Item Name:** \*40\* Start Date: **Start Qty: 40.00** 5/05/14 **Cust Item ID:** Required Date: 5/05/14 Req'd Qty: 40.00 \*40\* **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop SPC (Y/N): Date: QC: Date: Plan Reject Insp. Sequence ID/ **Operation** Tool ID Tool # Accept Reject Set Up/ Number Stamp **Work Center ID** Code Qty **Qty Description Run Hours** DAS 130 QC8- Inspect parts - second check 0.00 37 9-89 14.06.07 \*120\* QC 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: WHO 0.00 140 14-06-26 MAL \*140\* Packaging 0.00 Memo Packaging -150 QC21- Final Inspection - Work Order Release 0.00 MCJ 14-06-17 OC 0.00 Memo

Quality Control

DQA: Date:			<del></del>	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ONDER HOR			WAREL OF DATE		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION			AGA	AINST DE	PARTMENT/	PROCESS	
Part N	- ا ۱٥٠					Rework Scrap Use-as-is Suspected Unapproved		Thern	Machining Sma	stube all Fab ishing posite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desc	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		RAG VG. RAG											
							FAI	ULT CAT	EGORY				
Landir		Bending Centre Not Concentric Cracks				General Bend BOM/Route Broken/Damage/Defect		Folio/Program Grain Hardware			Outside Dim Over/Under Part Incorrec	tolerance	Pressure/Forced Set-up Temperature/Cure
		Crimp/Kin Cuffs Crushing	ık/Ripple,	/Wave		Burrs Contamination Countersink		Instruct	on Incomplete/Unqualifie ions Incomplete/Unclear ned/off center	ed	Part Lost/Mi Part Moved Positioned W		Weld Wrong Stock Pulled
		Heat Trea Inspection Marks/Ch	n Strip in atter	Tube		Cut Too Short Drawing Drill Holes		Mislabe Misread Off-set	I	<u>.</u>	Power Loss/S	Surge	Other
		Turning So Wave/Tw		e		Finish Fit/Function		4	Calibration Sequence				

May-06-14 8:09:14 AM

Work Order ID: 119001

\*119001\*

Parent Item:

D3404-1

\*D3404-1\*

Parent Item Name: GHW/ Lug

**Start Date:** 5/05/14

Required Date: 5/05/14

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP Rev:A05.09.01New issueKJ/JLM

IPP rev B 09.01.28 new geometry rev.C

EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primar Item Locatio	,	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No		100	f	3.8812	0.2291	10			
*M304B0	750X2 F	<b>500</b> *						**				

## |\*M304B0 750X2 500\*

304 BAR .750 X 2.50

<b>Location</b>	Loc Oty	Loc Code	,
MAT007	3.8812		P 3, 243
M128085	0.7812		/
M128496	3.1		0 6 023
H 129287			

DQA: Date:	
WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date: Work Order or	AEROSPACE
Work Order: DISPOSITION AGAINST DEPARTMEN	IT/PROCESS
Rework Skid-tube Crosstube	Water Jet Engineering
Part No. Scrap Machining Small Fab Pr	rod. Eng. Coor. Quality
Use-as-is Thermoforming Finishing Rec/St	ore/Packaging Other Other
NCR No Suspected Unapproved Large Fab Composite	Supplier
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date	Verification QC Inspector
Design	
Doc/Data Doc/Data	
Equip/Tooling	·
Handling/Pre	
Material	
Operator	
Offset/Setup	
Process	
Supplier	
Training	
Transport	·
Unapproved	
FAULT CATEGORY	
Landing Gear General  Bending Bending Bend Folio/Program Outside Di	mensions Pressure/Forced
	er tolerance Set-up
	H H
	<b>—</b>
Crimp/Kink/Ripple/Wave   Burrs   Inspection Incomplete/Unqualified   Part Lost/!   Cuffs   Contamination   Instructions Incomplete/Unclear   Part Move	
Crushing Countersink Misaligned/off center Positioned	<u> </u>
Heat Treat Cut Too Short Mislabeled Power Los	
Inspection Strip in Tube Drawing Misread	10000
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

DART AEROSPACE LTD	Work Order:	117001
DART AEROST AGE ETO	Part Number:	D3404-1
Description: GHW Lug	Fall Humber.	
Livernostian Dwg: D3404 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	FIRST	AK HOLL III		_		_		
	X	First Artic	le	Proto	Prototype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.510	+0.008/-0.001	1,514	/		MJP-04	Vern		
R0.65	+/-0.030	0 450	/_		, , ,			
0.125	+/-0.010	0 125						
0.500	+/-0.010	0, 150	/		1			
2.14	+/-0.030	) 138	/		3/006	Hight gunge		
1.30	+/-0.030	1,300	/		MJP-04	vun		
R2.30	+/-0.030	2 300	/		, , ,			
1.14	+/-0.030	1 140	/					
2.58	+/-0.030	2,578			<b>*</b>	4		

L			DAS		
Γ	Measured by:	Audited by:	37	Prototype Approval:	N/A
-			9-89	Date:	N/A
	Date:	Date.	14.06.05		

			Revised by	Approved
Rev	Date	Change	KJ/JLM .	11
Α	06.04.12	New Issue	KJ/DD	
В	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD /	- Just

D3404-1 GHW LUG

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 119001 MLJ

DRAWIN STANDA B6-2, 2.3	G REDI RDS AI 10 RAD	RAWN I ND TRA WAS 2.	N SOLIDWORKS WITH CURRENT NSFERED TO "B" SIZE BORDER. 13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02	
UPDATE	M-SPE	C		PH	05.06.14	
NEW IS	SUE		PH	05.03.08		
7.4			BY	DATE		
DESIGN PH DA			DART AEROSP	ACE L	TD	
N .	A	JS	HAWKESBURY, ONTA	RIO, CANA	DA	
KED	1	<u> </u>	DRAWING NO.		REV. C	
MFG. APPR.		M	↑D3404		SHEET 1 OF 2	
	<u> </u>	100/	TITLE		SCALE	
DE APPR.			GHW LUG	NTS		
	N N KED APPR.	B6-2, 2:30 RAD UPDATE M-SPE NEW ISSUE  N F N A KED APPR. DVED	B6-2, 2.30 RAD WAS 2.  UPDATE M-SPEC  NEW ISSUE  N PH  N AUS  KED  APPR.  DVED	NEW ISSUE  DESCRIPTION  N PH DART AEROSP  HAWKESBURY, ONTA  GED DRAWING NO. D3404  DVED TITLE  PR. TITLE  GHW LUG	B6-2, 2-30 RAD WAS 2-13, C7-21-14 DIM WAS 1-20.	

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.34 lbs

08.12.02

С

